**Takt Time VSM Template Example**

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| Takt Time is Total Production Time (minutes) / Average Demand (units). |
| TIME AVAILABLE | TOTAL TIME | BREAKS (min) | CLEANUP (min) | MINUTES AVAILABLE |
| DAYS PER YEAR | 221 |
| HOURS PER DAY | 8 | 30 | 10 | 440.00 |
|  |  |  |  |  |  |  |
| TAKT TIME | PRODUCT 1 | PRODUCT 2 | PRODUCT 3 | PRODUCT 4 | PRODUCT 5 | TOTALS |
| Annual demand | 50,000.00 | 100,000.00 | 100,000.00 | 50,000.00 | 50,000.00 | 350,000.00 |
| Daily demand | 226.24 | 452.49 | 452.49 | 226.24 | 226.24 | 1,583.71 |
| Percent of total sales | 14% | 29% | 29% | 14% | 14% | 100% |
| Takt Time (minutes per unit) | 1.94 | 0.97 | 0.97 | 1.94 | 1.94 | 7.78 |
| Cycle time per Operator | 5 | 4 | 2.5 | 2 | 6 | 19.50 |
| Number of Operators | 2.57 | 4.11 | 2.57 | 1.03 | 3.09 | 13.37 |

DAILY DEMAND Right-Click Chart to Edit Data in Excel

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